

# Work Order ID 55169

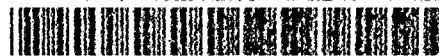


Page 1

January 8, 2010 10:14:31 AM

Item ID: D205-634-041

Accept



Setup Start



Revision ID:

Item Name: Replacement Skidtube

Stop



Start Date: 08/01/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 26/01/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

*PL*

Date: 10-1-08

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2580	Rev D

100 0.00



DOCUMENT CONTROL

DC

Document Control

Memo 0.00

Photocopy D205-634 bluefile &amp; type labels per PPP D205-634-041 CHG002

*PL 10-1-26*

110



BENDING MACHINE - SKIDTUBES

CNC Bend 1

CNC Delta 100 Bender

Memo 0.00

1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580

*PL 10-1-18**5/16/18*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

**Work Order ID 55169**

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Required Date: 26/01/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120



Skidtubes

Memo

0.00

AWM10-1-18

Skidtubes

1- Deburr ends

2- C'sink holes as per dwg without cutting fluid

3- Prepare tube for welding, remove alodine as required.

4- Scribe batch number insied aft end of tube.

130



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**Work Order ID 55169**

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January 8, 2010 10:14:32 AM

Item ID: D205-634-041

Accept

Setup Start



Revision ID:

Item Name: Replacement Skidtube

Stop



Start Date: 08/01/2010 Start Qty: 100



Cust Item ID:

Required Date: 26/01/2010 Req'd Qty: 100



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

140



Skidtubes

Memo

0.00

Skidtubes

1-Weld step D2576 as per Dwg. D2580 and QSI 004  
A/R Aluminum Rod

M112860

BE 10/01/19

2-Prep per QSI 005 and weld crossbolt spacers D2579 as per Dwg. D2580, QSI  
004.For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill  
A/R Aluminum Rod

M112860

BE 10/01/19

3-Grind welds as per Dwg D2580 Grind flush ridge made from bending

4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64",  
adjust stopper not to hit web. Deburr5-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580.  
Deburr holes

6-Drill pilot holes for aff cap using DT 8215 Open holes to 0.208". Deburr

7-Drill pilot holes for Towring using DT8091, open to .640" and Deburr

AWM 10-1-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Start Date: 08/01/2010 Start Qty: 1.00



Current Item ID:

Required Date: 26/01/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
Description

150



QC10- Inspect visual per QSI004- ground welds

QC

Memo

Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
0.00							
0.00	31010120						

Quality Control

160



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00	31010120	(X) f
0.00		

Quality Control

170



Pressure Wash per QSI005 4.3

HandFinish

Memo

0.00	31010121	(X) 6
0.00		

Hand Finishing

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

180



Powdercoat

Powder Coating

Operation  
Description

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

Set Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp1/13/70  
10-01-20

(X) S

Memo

0.00

11:00AM  
3209-  
11:30AM

190



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

BR 10-01-22

Q

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Cust Item ID:

Required Date: 26/01/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

200



HandFinish

Memo

0.00

Hand Finishing

1-Install inserts &amp; wearplates &amp; Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates

A/R Sikaflex-291 11/2345Sikaflex expire date: 10/08

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step &amp; Aft Cap with Sikaflex. Clean excess adhesive

A/R Sikaflex-291 11/2345Sikaflex expire date: 10/08

5-Wing Walk as per Dwg D2580 and QSI 005 4.4

Batch: 11/2900

7  
BL 10-01-22 Ø

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Start Date: 08/01/2010 Accept Qty: 1.00



Cust Item

Required Date: 26/01/2010 Req'd Qty: 1.00



Customer

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

210

QCS- Inspect part completeness to step on W/O

0.00

2) Sol 6122

40



QC

Quality Control

Memo

0.00

Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

220

Packaging

0.00



Packaging

Memo

0.00

Identify and pack for shipping as per PPPD205-634-041

Location:

PPP Rev: J

10/1/2010

230

QC21- Final Inspection - Work Order Release

0.00



Quality Control

Memo

0.00

10/1/2010  
MF  
10-1-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

January 8, 2010 10:14:36 AM

Work Order ID: 55169



Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

Start Date: 08/01/2010

Required Date: 26/01/2010

Comments: IPP Rev N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ  
IPP Rev O 06.02.28 Added paperwork EC  
IPP Rev P 07-07-09 SS Wearplates & Gaskets JLM

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D2580-1	DP	Manufactured	No			110	Each	11.0000	1.0000			

205 Skidtube bent detail



## Warehouse

### Location

#### Main Warehouse

LG	7	
54120	1	
54541	2	
54648	2	
54697	2	

#### Main Warehouse

ST	4	
54500	2	
54647	2	

D2576-3

Manufactured No

140 Each 151.0000 1.0000



Step (machining detail)

## Warehouse

### Location

#### Main Warehouse

ST	151	
43504	3	
46661	101	
52215	47	

Page 1

10

AVN 10-1-18

1 BE 10/01/19

# Picklist Print

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January 8, 2010 10:14:36 AM

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Start Date: 08/01/2010

Required Date: 26/01/2010

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ  
IPP Rev:O 06.02.28 Added paperwork EC  
IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D2579		Manufactured		No		140	Each	381.0000	20.0000			



Crossbolt Spacer

Warehouse	Loc Qty	Loc Code
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Location

Main Warehouse

LG	259	
51525	4	
53780	3	
54543	38	
54642	214	

20 SC 10/01/9

Main Warehouse

ST	122	
43988	4	
46434	4	
46956	2	
47797	9	
48272	2	
51314	71	
51315	30	

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January 8, 2010 10:14:36 AM

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IPP Rev: O 02-02-28 Added paperwork EC  
IPP Rev:P 03-07-09 SS Wearplates & Gaskets JLM

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D2855		Manufactured	No			200	Each	159.0000	1.0000			



Cap

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
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Location

Main Warehouse

FP6	159	
50513	1	
50770	1	
51539 ✓	42	
53791	115	

1 Blk 10-01-22

AN3-5A

Purchased

No

200	Each	1,965.000	2.0000
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Bolt

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST	1965	
100188	188	
105057 ✓	1777	

2 Blk 10-01-22

# Picklist Print

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January 8, 2010 10:14:36 AM

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Start Date: 08/01/2010

Required Date: 26/01/2010

Comments: IPP Rev:N 02.08.28. FP was QC5 in Step 27; Added QC5 to Step 30. KJ  
IPP Rev: O 06.07.28 Added paperwork EC  
IPP Rev: P 07.07.09 SS Wearplates & Gaskets JLM

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ AN960JD10L	Replacement Purchased	Mfg/ Purchased	Bin No	Primary	Last	Route 200	Unit of Each	Qty on 4,741.000	Remaining 2.0000	Qty	Date	Status
Washer												



Washer

<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-------------------------------------	----------------	-----------------

Main Warehouse

ST	4741	
101291	16	
104885	16	
105793	105	
109632	170	
110985	4434	

2. 6/10-01-22,

ALS7-1032-130	Purchased	No	200	Each	1,494.000	50.0000	
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Insert

<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-------------------------------------	----------------	-----------------

Main Warehouse

ST	1494	
105855	16	
108606	52	
111529	152	
111779	313	
112772	11	
113238	950	

50 6/10-01-22

ALS7-1032-130 110511

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IPP Rev. O 06.08.28 Added paperwork EC  
IPP Rev:P 07.07.09 SS Wearplates & Gaskets JLM

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ AN3C4A	Replacement	Mfg/ Purchased	Bin	Primary	Last	Route	Unit of Each	Qty on 1,181.000	Remaining 50.0000	Qty	Date	Status
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BOLT

## Warehouse Loc Qty Loc Code

### Location

#### Main Warehouse

ST	1181	
112314	13	
112720	12	
112724	3	
112829	1	
112991	2	
113121	64	
113226	586	
113422	500	

50 Blk 10-a-22

AN960C10L



Purchased No

200 Each 388.0000 50.0000



washer

## Warehouse Loc Qty Loc Code

### Location

#### OFFSHORE

FG	113288	100
103585		100

50 Blk 10-01-22

#### Main Warehouse

ST	288	
112116	128	
112612	160	

50 Blk 10-01-22

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Start Date: 08/01/2010

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IPP Rev. O 06.03.28 Added paperwork EC  
IPP Rev:P 07.07.09 SS Wearplates & Gaskets JLM

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D3566-13		Manufactured	No			200	Each	93.0000	1.0000			



Gasket

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

FP	91	
51606	9	
53461	82	

1 BK 10-01-02

Main Warehouse

ST	2	
45717	1	
50265	1	

\_\_\_\_\_

D3566-5

Manufactured No

200 Each 14.0000 1.0000



Gasket

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

FP 55026	10	
53804	10	

1 BK 10-01-02

Main Warehouse

ST	4	
36113	1	
46186	1	
47318	1	
51260	1	

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IPP Rev. O 06.08.28 Added paperwork EC  
IPP Rev:P 07.08.09 SS Wearplates & Gaskets JLM

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Units of	Qty on	Remaining	Qty	Date	Status
D3566-1		Manufactured		No		200	Each	25.0000	2.0000			



Gasket

Warehouse      Loc Qty      Loc CodeLocation

## Main Warehouse

FP	55016	20
	52512	3
	54480	17

2 BK 10-01-22

## Main Warehouse

ST	5
	46349
	51218
	51259

\_\_\_\_\_

D3564-11

Manufactured No

200 Each 15.0000 1.0000



Wearshoe

Warehouse      Loc Qty      Loc CodeLocation

## Main Warehouse

FP19	13
52125	13

1 BK 10-01-22

## Main Warehouse

ST	2
	45823
	50112

\_\_\_\_\_

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 IPP Rev: O 06-02-28 Added paperwork EC  
 IPP Rev:P 07-17-09 SS Wearplates & Gaskets JLM

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacerem	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D3564-13		Manufactured	No			200	Each	33.0000	1.0000			



Wearshoe

## Warehouse

### Location

Main Warehouse

FP17	21
51611✓	21

1 BK 10-01-22

Main Warehouse

ST	12
45409	2
46495	10

\_\_\_\_\_

D3564-9

Manufactured No

200 Each 12.0000 1.0000



Wearshoe

## Warehouse

### Location

Main Warehouse

FP19	10
53806 ✓	10

1 BK 10-01-22

Main Warehouse

ST	2
44659	1
45825	1

\_\_\_\_\_

# Picklist Print

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Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D3564-5		Manufactured	No			200	Each	13.0000	1.0000			



Wearshoe

## Warehouse

### Location

OFFSHORE

FG 55333

Loc Qty

Loc Code

34806

2

1 BK 10-01-22,

Main Warehouse

FP19

9

51925

1

53805

8

Main Warehouse

ST

2

45824

1

47433

1

D2594-3

Manufactured

No

200

Each

346.0000

16.0000



O-Ring, 205 Skidtube

## Warehouse

### Location

Main Warehouse

FP

27

51613

27

Main Warehouse

ST

319

52562 ✓

319

16 BK 10-01-22

# Picklist Print

Page 10

January 8, 2010 10:14:36 AM

Work Order ID: 55169



Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

Start Date: 08/01/2010

Required Date: 26/01/2010

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ  
IPP Rev: O 06.02.28 Added paperwork EC  
IPP Rev:P 07-07-09 S Wearplates & Gaskets JLM

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D2594-1		Manufactured		No		200	Each	234.0000	16.0000			



Plug, 205 Skidtube

## Warehouse      Loc Qty      Loc Code

### Location

#### Main Warehouse

FP	106
54008	1
54643	105

15 bl 10-01-22

#### Main Warehouse

ST	128
42221	16
42807	92
43884	3
46435	2
51527	9
51757	6

1 bl 10-01-22

55002

**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. D
		D2580	SHEET 1 OF 3
DATE	TITLE		SCALE
07.02.27	205 SKIDTUBE ASSEMBLY		NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

**RELEASED**  
07-06-28

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AEIS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

**GENERAL NOTES:**

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:  
SEE NOTES ON  
PAGE 2 FOR D2580-041 AND  
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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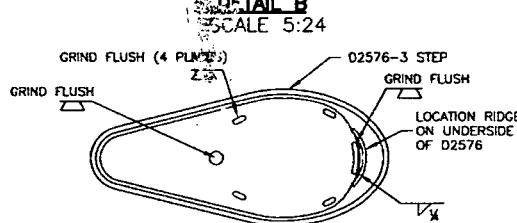
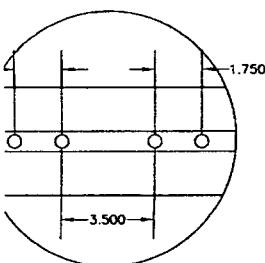
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WORK ORDER  
NO. 55169

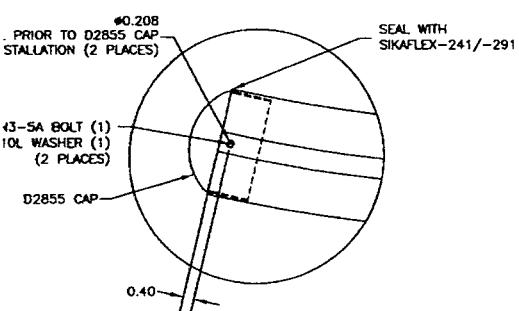
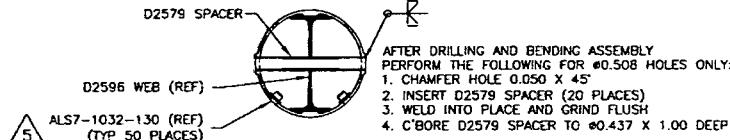
BJ10-1-08

**DETAIL A**

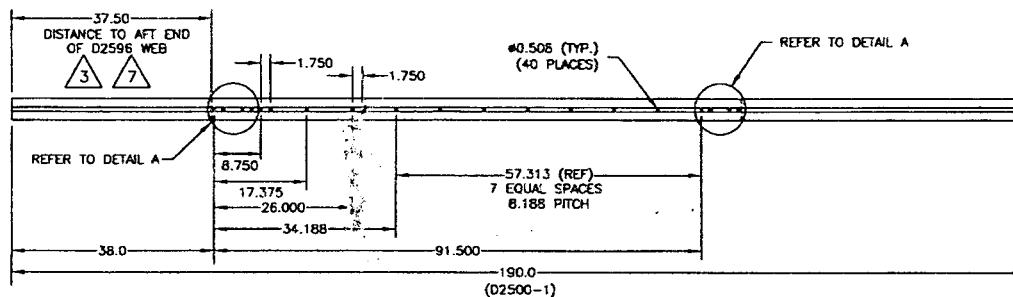
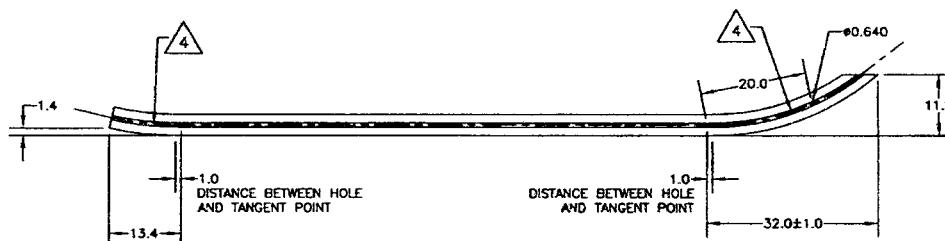
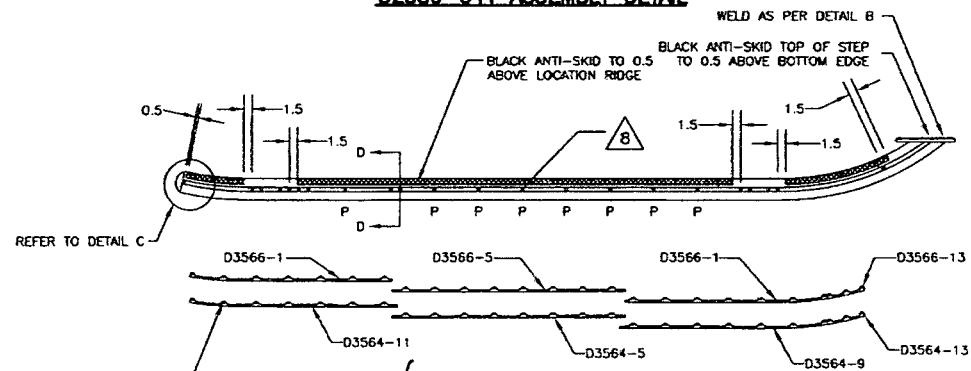
SCALE 5:24

**RELEASED**  
07-06-28**DETAIL C**

SCALE 5:24

**SECTION D-D**  
SCALE 5:24**-041 NOTES**

FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB  
 POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

**D2580-1 DRILLING DETAIL****D2580-1 BENDING AND CUTTING DETAIL****D2580-041 ASSEMBLY DETAIL**AN3C4A BOLT (1)  
AN960C10L WASHER (1)  
(50 PLACES)

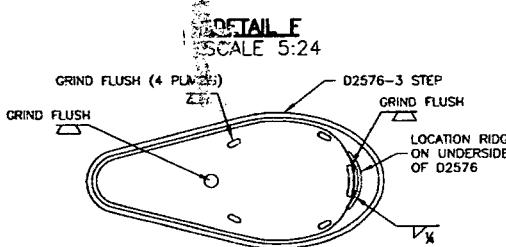
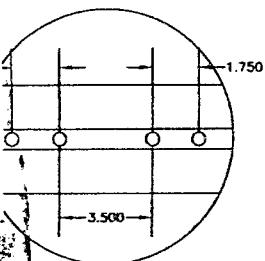
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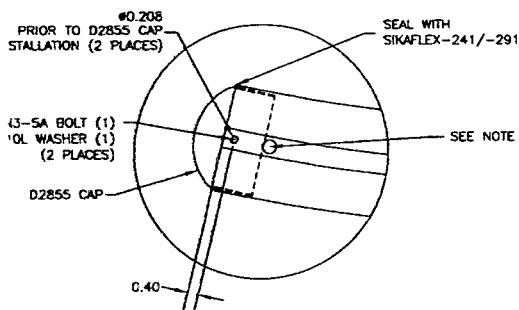
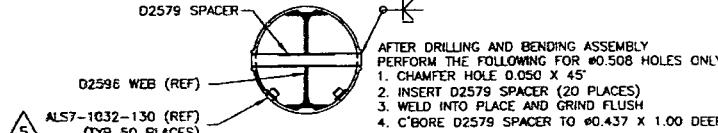
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CHECKED	APPROVED		DRAWING NO. D2580
DATE			REV. D SHEET 2 OF 5
07.02.27			TITLE 205 SKIDTUBE ASSEMBLY

**DETAIL E**

SCALE 5:24

**RELEASED**  
07-26-26**DETAIL G**

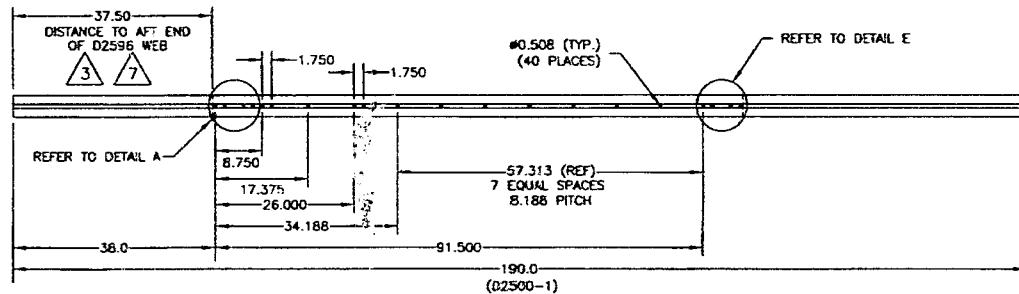
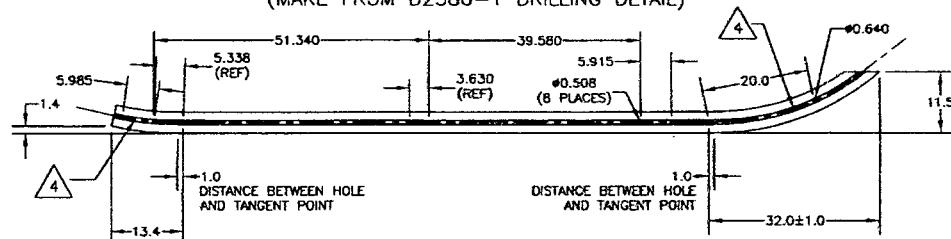
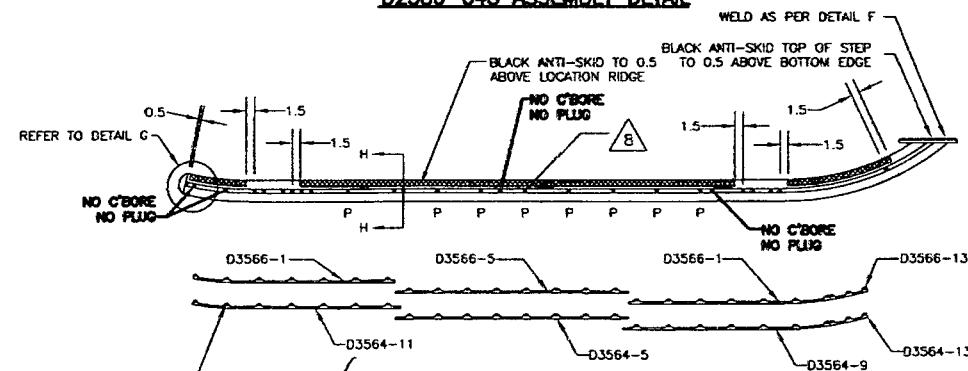
SCALE 5:24

**SECTION H-H**  
SCALE 5:24

5

**-045 NOTES**

FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB  
 POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3  
 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4  
 IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE  
 WITH THE SPACER AT THIS LOCATION

**D2580-1 DRILLING DETAIL****D2580-5 BENDING AND CUTTING DETAIL**  
(MAKE FROM D2580-1 DRILLING DETAIL)**D2580-045 ASSEMBLY DETAIL**AN3C4A BOLT (1)  
AN960C10L WASHER (1)  
(50 PLACES)

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RH	RH		REV. D
CHECKED	APPROVED		DRAWING NO. D2580
			SHEET 3 OF 3
DATE			TITLE
07.02.27			205 SKIDTUBE ASSEMBLY

NO. 221

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliott  
Job number: 54202  
Part number: D205 634 041  
Description: 205 skid tube  
Welding Process: Tig[] Mig[]  
Base material: Aluminium  
Current: AC[] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[] fail[]  
Penetration: pass[] fail[]

UNACCEPTABLE

Cracks: pass[] fail[]  
Undercut: pass[] fail[]  
Pin holes: pass[] fail[]  
Overlap (cold lap) pass[] fail[]  
Porosity (surface): pass[] fail[]  
Coloration: pass[] fail[]

Qualifier Barclay Elliott Date of Test Coupon 09.12.17  
Welder Barclay Elliott Date of Test Coupon 09.12.17

The above named individual is qualified in accordance with AWS D17.1.2001 to weld